

Work Order ID 51673-1

August 27, 2009 8:41:07 AM

split 25

Item ID: D3405-041

Revision ID: B

Item Name: Lug Assembly

Start Date: 8/27/09

Start Qty: 34.00

Required Date: 9/11/09

Req'd Qty: 34.00

Reference:

Approvals:

Process Plan:

MS

Date:

08-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3405

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405 : Dwg Rev: B Prog Rev: B : 2-
Deburr if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) 8/25/09/17

contos
x44

B 9-9-16

B 9-9-16

PTG ->

44

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|------------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | 4/6 split for 25 parts | U | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 51673

August 27, 2009 8:41:07 AM



Item ID: D3405-041
Revision ID: B
Item Name: Lug Assembly

Accept



Setup Start
Stop



Start Date: 8/27/09 Start Qty: 34.00
Required Date: 9/11/09 Req'd Qty: 34.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start
Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130 | NC BRAKE | 0.00 | | | | | | | |
| | Brake NC | 0.00 | | | | 44 | | | |
| Brake NC | Memo Deburr! iForm using DT8204 as per Dwg D3405 | | | | | | | | |
| 140 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | QC | 0.00 | | | | | | | |
| Quality Control | Memo | | | | | | | | |
| 150 | Large Fab | 0.00 | | | | | | | |
| | Large Fab | 0.00 | | | | | | | |
| Large Fab | Memo Weld as per Dwg D3405 Identify as D3405-041 | | | | | | | | |

SB 09/09/21

2) 8/27/09/27

count
44

SB 09.09.24.

M 102000.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 51673

August 27, 2009 8:41:07 AM



Page 3

Item ID: D3405-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 8/27/09

Start Qty: 34.00



Cust Item ID:

Required Date: 9/11/09

Req'd Qty: 34.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

lpc 09-09-25

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

→ Solder

counted
K25

180

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

1112260

START TIME:

9:30am

FINISH TIME:

OVEN TEMPERATURE:

400°F

700 09/09/25

K25

Q

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 51673

August 27, 2009 8:41:07 AM



Page 4

Item ID: D3405-041
Revision ID: B
Item Name: Lug Assembly

Accept



Setup Start



Stop



Start Date: 8/27/09 Start Qty: 34.00
Required Date: 9/11/09 Req'd Qty: 34.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan:
QC:

Date:
Date:

Tooling:

Date:
Date:

SPC (Y/N):

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BK 09-09-28.

(25)

200



Packaging

Packaging

Identify as per dwg & Stock Location: 474

Memo

0.00

0.00

9/9/28 (250) SP

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/09/29 MF 09-09-29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:41:06 AM

Page 1

Work Order ID: 51673

Parent Item: D3405-041RevB

Parent Item Name: Lug Assembly


Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 34.00

Required Qty: 34.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3404-1RevC | | Manufactured | No | | | 100 | Each | 33.0000 | 34.0000 | 44 | | |
|  | | | | | | | | | | | | |
| GHW Lug | | | | | | | | | | | | |

~~1899-16~~

M304S11GA



304/316 0.125 Sheet

Purchased

No

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 33 | |
| 45372 | 8 | |
| 50471 | 25 | |

150

sf

63.6179

5.5116



✓

25

8P09.09.23

1899-16

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 63.61789789 | |
| 111018 | 63.6178979 | |

111018

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

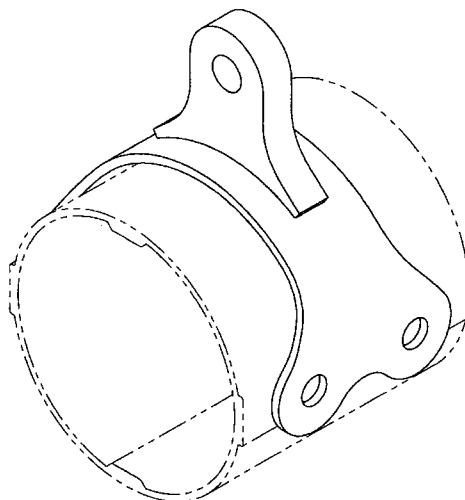
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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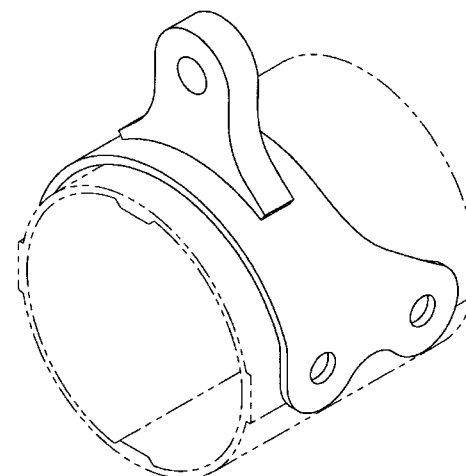
NOTE: Date & initial all entries

| ITEM No. | QTY. -041 | QTY. -043 | PART NUMBER | DESCRIPTION |
|----------|-----------|-----------|-------------|--------------|
| 1 | X | | D3405-041 | LUG ASSEMBLY |
| 2 | | X | D3405-043 | LUG ASSEMBLY |
| 11 | 1 | 1 | D3404-1 | GHW LUG |
| 12 | 1 | | D3405-1 | GHW BRACKET |
| 13 | | 1 | D3405-3 | GHW BRACKET |

△B



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

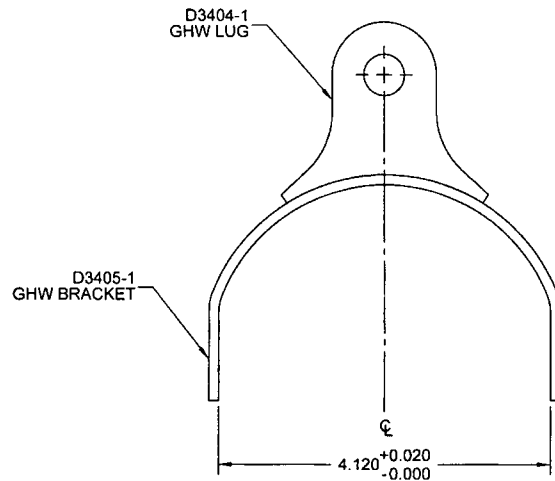
51673

RELEASED
A/12/18 MP

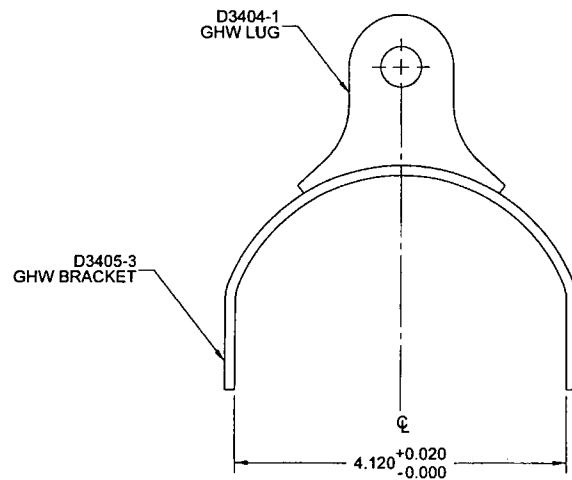
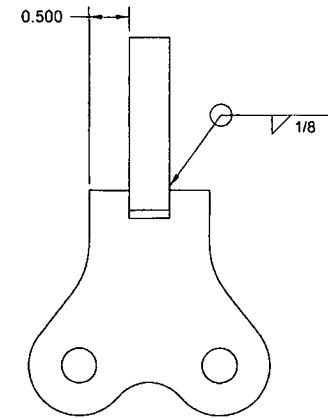
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

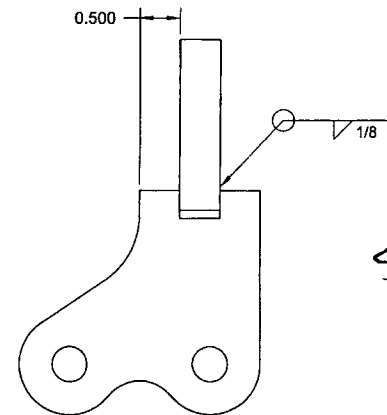
| | | | | |
|------------|--|--|--------------|----------|
| B | DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100. | | AJS | 08.09.19 |
| A | NEW ISSUE | | PH | 05.03.08 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | AJS | | | |
| CHECKED | | DRAWING NO. | REV. B | |
| MFG. APPR. | | D3405 | SHEET 1 OF 4 | |
| APPROVED | | TITLE | SCALE | |
| DE APPR. | | GHW LUG ASSEMBLY | NTS | |
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D3405-041 LUG ASSEMBLY



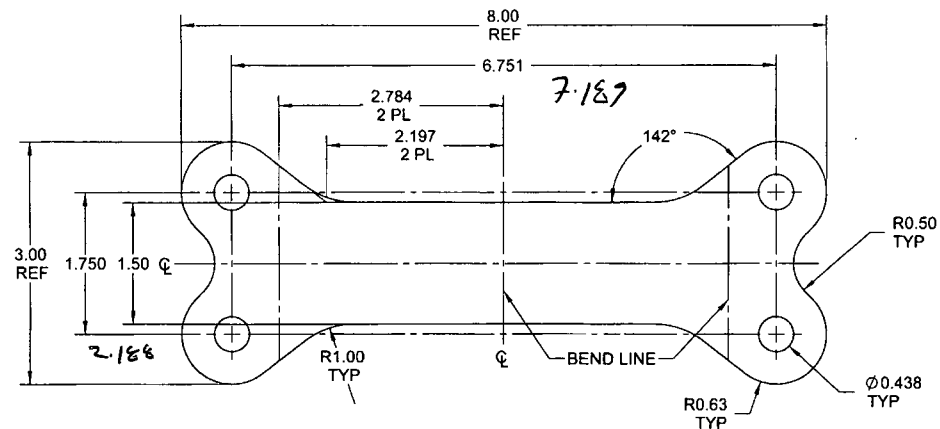
D3405-043 LUG ASSEMBLY



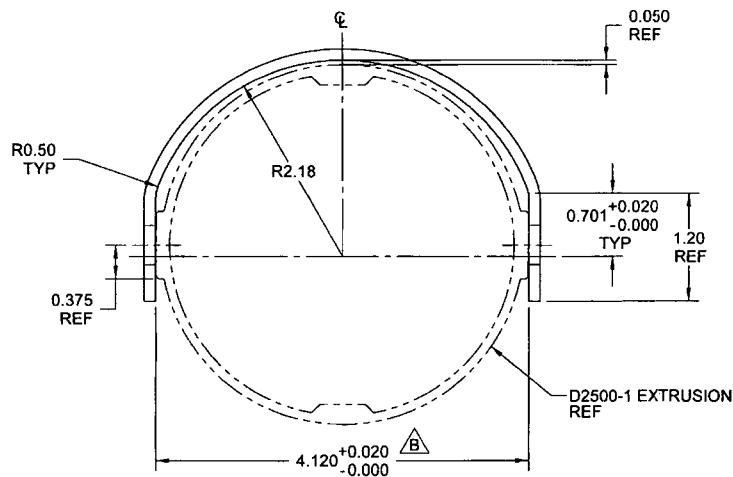
51673

RELEASED
06/12/18 M/T

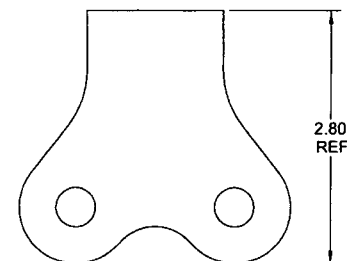
| | | | |
|------------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3405 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GHW LUG ASSEMBLY | NTS |
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D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

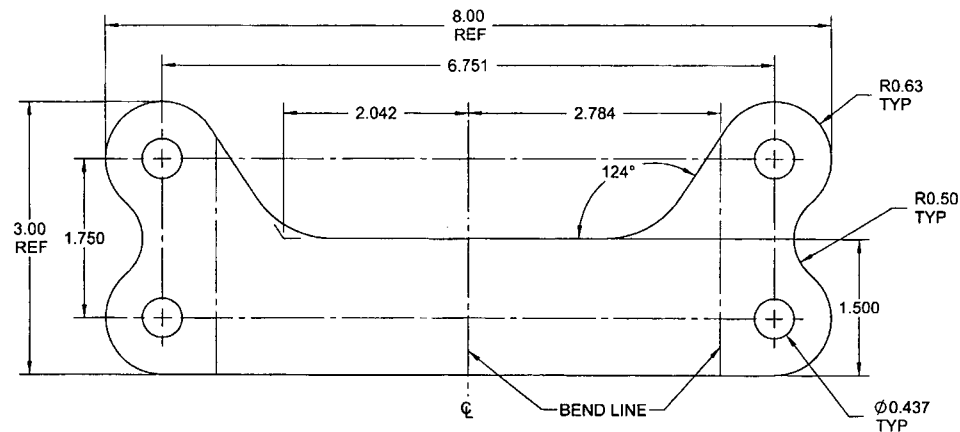
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

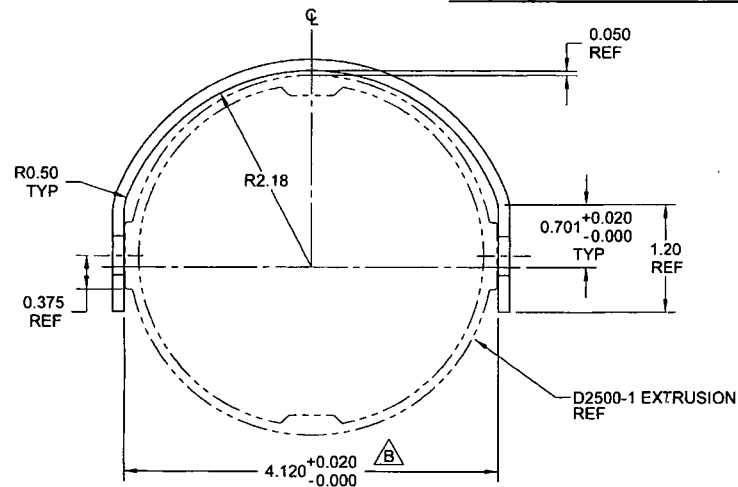
| | | | |
|------------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3405 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GHW LUG ASSEMBLY | NTS |
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51673

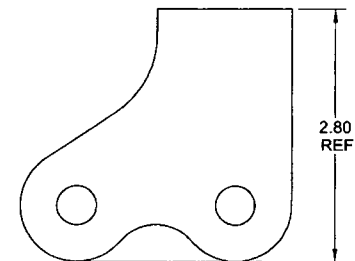
RELEASED
08/09/19



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

51673

RELEASED
08/12/18 N/A

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3405 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GHW LUG ASSEMBLY | NTS |
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